

wherein the first positioning device (53) and the second positioning device (69) are arranged in series in the first direction (X), thereby the workpiece (W) is transferred only in the first direction by one of the first positioning device and the second positioning device; and the workpiece is not transferred in the second direction (Y); and

wherein the first positioning device (53) and the second positioning device (69) are constructed in a manner such that the first positioning device and the second positioning device may alternately transfer the workpiece (W) in the first direction (X) during punching operation, so that the workpiece (W) can be advancingly shifted in the first direction (X) by alternative operations of the first positioning device (53) and the second positioning device (69), and that the workpiece (W) can be reversingly shifted in the first direction (X) by the alternative operations of the first positioning device (53) and the second positioning device (69).

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16. (Twice Amended) A punching machine according to Claim 14, wherein the second positioning device (69) includes a third clamp (69C, 69D) to clamp the first margin of the workpiece (W) in the first direction;

wherein the second positioning device (69) further includes a fourth clamp (69A, 69B) to clamp the second margin opposite to the first margin of the workpiece wherein the fourth clamp is fixedly mounted to the second positioning device; and

wherein the third clamp is movably mounted to the second positioning device in the second direction (Y) so that the third clamp can be moved to approach to the fourth clamp in the second direction thereby enabling the clamping of the workpiece even though the size of the workpiece in the second direction varies.

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